

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020093**Date Inspected:** 20-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

SMAW welding of critical repair (R6) weld is identified as 1G-004 of SB022-104 for SB104 West. The welder is identified as 259566. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and CWR-2699.

SMAW welding of critical repair (R6) weld is identified as 1G-005 of SB022-104 for SB104 West. The welder is identified as 259566. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and CWR-2693.

ABF QC NDT UT personnel performing UT on CWR (R5) welds they found R6 reject able indications the weld is identified as SB025-108-035,026,045,049 of SB108 East. This is informed to ZPMC QC Mr.Xu tao to prepare CWR and further action.

ABF QC NDT UT personnel performing UT on CWR (R4) welds they found R5 reject able indications the weld is identified as SB022-104-002, 005,006 of SB106 West. This is informed to ZPMC QC Mr.Xu tao to prepare CWR and further action.

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ABF QC NDT MT personnel performing MT on hold back locations of inside stiffener (BKX7)  
Is progress of BK005A-002.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG bike path.  
The weld designations reviewed as follows  
BK004A2-013-016,018.

This QA inspector performed VT internal welds and cleanliness checked and the locations where need additional grinding and cleaning marked. ZPMC personnel repaired those locations. The bike path is identified as BK004B-001.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for

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your project.

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**Inspected By:** Kumar,Chadra

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer